

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017204**Date Inspected:** 27-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Tian Lei /Mr. Huang min**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY- 2

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint E5-SB1-021-019. Welder is identified as 204730. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW of weld joint E5-SB1-052-126~131. Welder is identified as 207465. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint E5-SB10-003-126~131. Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

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FCAW of weld joint E5-SB6-001-126~131. Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 3

Submerged Arc Welding (SAW) of weld joint LD3042-001-001. Welder is identified as 044780. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

SAW of weld joint LD3043-001-002. Welder is identified as 207288. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

FCAW of weld joint FB3265-001-065,066. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 4

FCAW of weld joint BP3085-001-113,114. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 7

FCAW of weld joint SA3077-005-001. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Xu hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-C-P2-F-2.

FCAW of weld joint SA3077-008-001. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Xu hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-C-P2-F-2.

During QA random in-process observations of the fabrication of OBG Lift 14 East Deck Panel (DP) DP3165A, this observed ZPMC personnel have performed Free Hand Flame Cutting for more than 300mm in length. Access to the areas being cut were not restricted due to cross sectional geometry and or position in so far as mechanical guides could not be used. The approximate cut length as measured by this QA was 960mm. Both Stiffener plates are identified as RS3266A. The stiffener plates are designated as Seismic Performance Critical Material (SPCM) on the approved drawing. The cut edges will be joined to SPCM member is identified as X4677B with Complete Joint Penetration (CJP) welds. These CJP weld joints are identified as DP3165-001-158 and 161. The stiffener plate materials mentioned above are 22 mm in thickness.

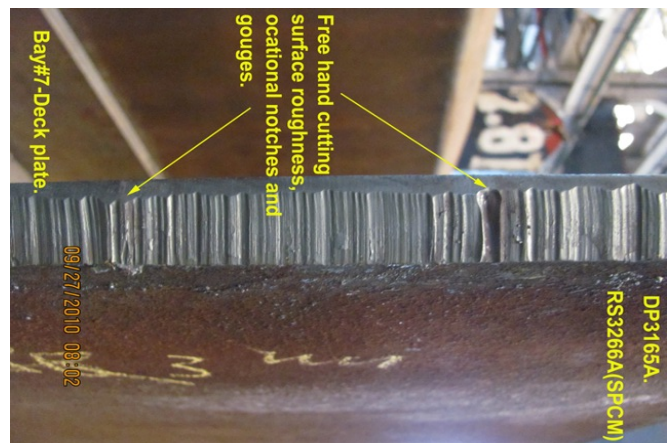
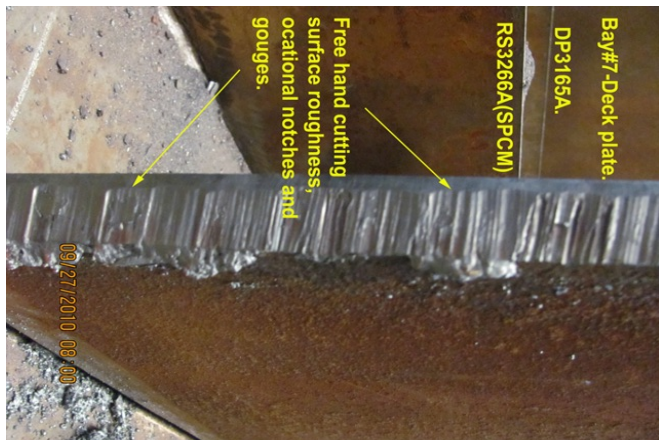
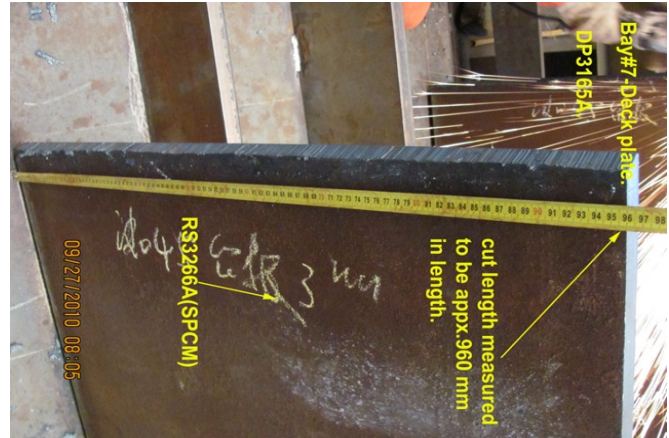
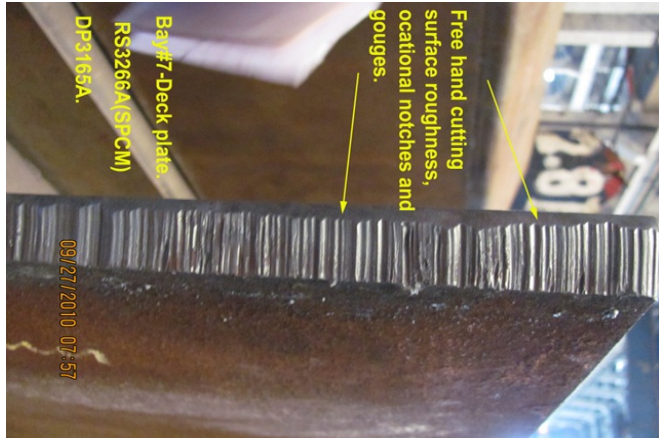
This QA generated an incident report on this date for the above issue, for further information see the incident

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report and attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
